

Work Order ID 57269

Wednesday, March 31, 2010 11:24:01 AM

Page 1

Item ID: D3911-041

Revision ID:

Item Name: Basket Installation Stud Assembly, Lower

Start Date: 3/31/2010 Start Qty: 6.00

Required Date: 4/5/2010 Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-4-1

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110



Small Fab

0.00

Memo

0.00

Small Fab

1- Assemble D3911-5 to D3911-1 and install rivet as per dwg
Trim rivet to 1.250" Full Length

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

MF 10-4-05

E/SO/04/05 (6)

(16)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00

N/A S

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Day calls for no Finish

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: STUG6

0.00

Memo

0.00

Per 3/31/10 (6)

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 57269

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Page 3

Item ID: D3911-041

Accept

Revision ID:

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Required Date: 4/5/2010 Req'd Qty: 6.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

QC

Quality Control

Operation
Description

QC21-Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/04/12 *[Signature]*
MF
10-4-5

W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 31, 2010 11:24:01 AM

Page 1

Work Order ID: 57269

Parent Item: D3911-041

Parent Item Name: Basket Installation Stud Assembly, Lower

Comments: IPP RevA: New issue DD verified by:EC
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD



IPP

Start Date: 3/31/2010

Required Date: 4/5/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D3911-1 | | Manufactured | No | | | 100 | Each | 8.0000 | 6.0000 | | | |
|  | | | | | | | | |  | | | |
| Basket Installation Stud, Lower | | | | | | | | | | | | |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST095

56954

8

8

Each

20.0000

12.0000

MF 10-4-1

D3911-5



Basket Stud Plate

Manufactured

No

100

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST095

57119

20

20

Each

80.0000

18.0000

MF 10-4-1

MS20615-4M20



RIVET

Purchased

No

100

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST323

113254

80

80

MF 10-4-1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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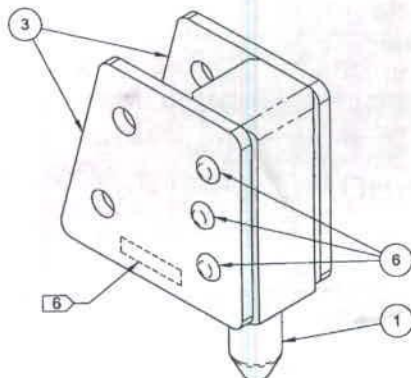
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NOTE: Date & initial all entries

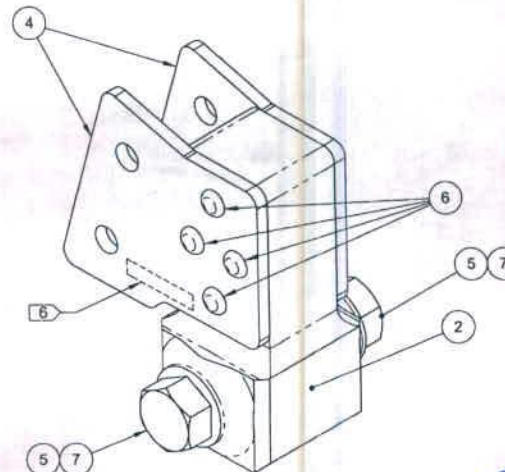
| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|--------------|--------------------------------|
| | X | | D3911-041 | BASKET INSTL STUD ASSY (LOWER) |
| | | X | D3911-043 | AFT EYEBOLT RECEIVER ASSY |
| 1 | 1 | | D3911-1 | BASKET INSTL STUD (LOWER) |
| 2 | | 1 | D3911-3 | AFT EYEBOLT RECEIVER |
| 3 | 2 | | D3911-5 | BASKET STUD PLATE |
| 4 | | 2 | D3911-7 | BASKET PLATE-EYEBOLT RECEIVER |
| 5 | | 2 | D4087-1 | CAP SCREW, PLASTIC, 3/8"X16 |
| 6 | 3 | 4 | MS20615-4M20 | RIVET |
| 7 | | 2 | MS21209-C610 | HELICAL |



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 1.17 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-03-22
MP

| | | | |
|--|---|--|------------------------|
| B | DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2) | JPH | 10.03.16 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JS | | |
| MFG. APPR. |  | | |
| APPROVED |  | | |
| DE APPR. |  | DRAWING NO. D3911 | REV. B SHEET 1 OF 3 |
| DATE | 10.03.16 | TITLE AFT HARDPOINT, BASKET | SCALE NTS |
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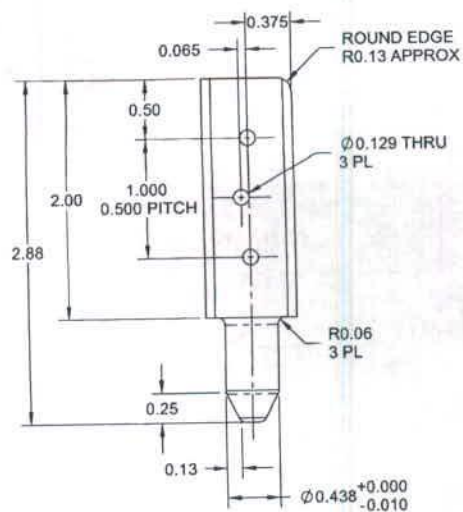
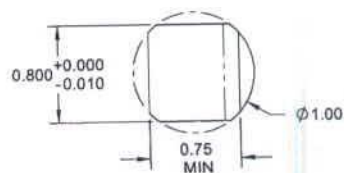
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



0.09 X 45° CHAMFER

1.250

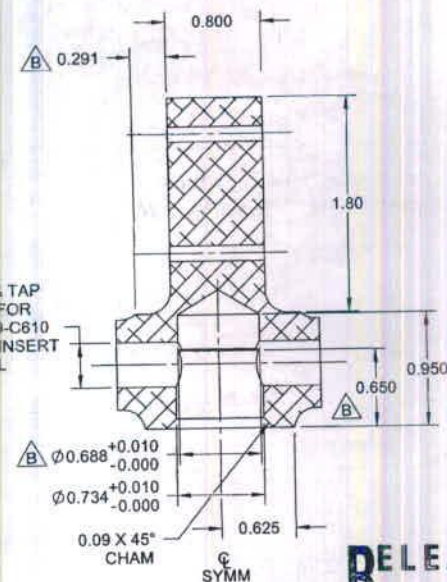
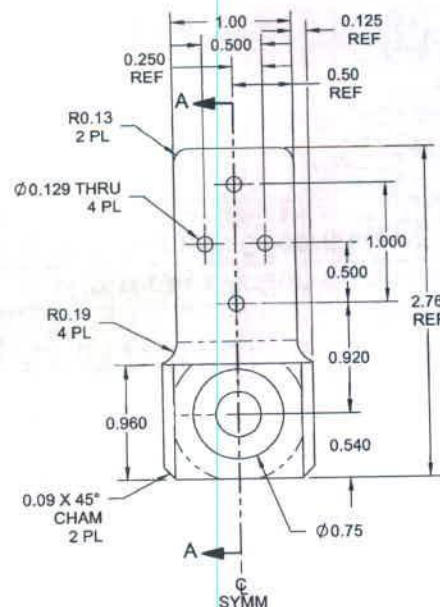
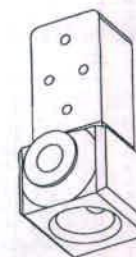
1.250

1.71 REF

0.230

0.625 REF

⌀ SYMM



SECTION A-A

RELEASED
2010-03-22

NOTES

- NOTES:**
- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -1: 0.36 lbs
-3: 0.74 lbs

| | | | | |
|------------|----------|---|--|--------------|
| DESIGN | JPH |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | DRAWING NO. D3911 | REV. B |
| CHECKED | | | | SHEET 2 OF 3 |
| MFG. APPR. | | | | SCALE |
| APPROVED | | | | NTS |
| DE APPR. | | | | |
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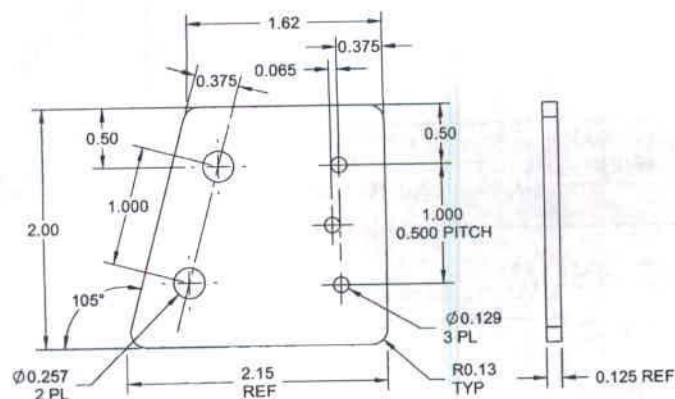
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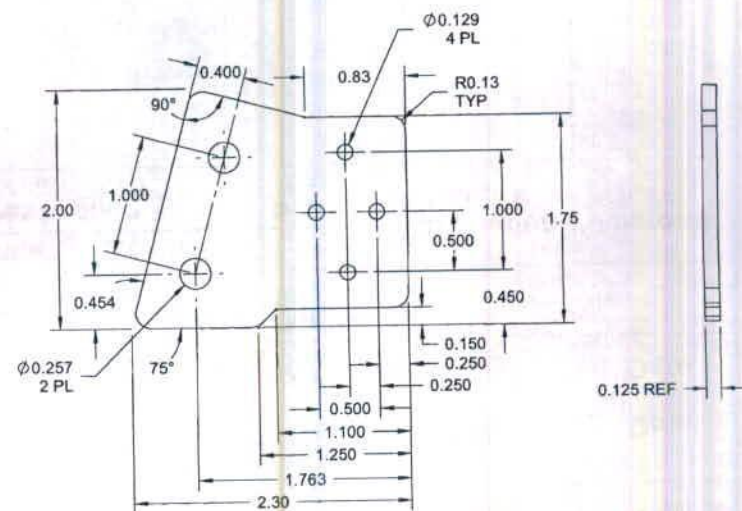
NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-03-22

| | | | |
|------------|----------|---|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JHH | | |
| CHECKED | | DRAWING NO. D3911 | REV. B |
| MFG. APPR. | | TITLE AFT HARDPOINT, BASKET | SHEET 3 OF 3 |
| APPROVED | | SCALE NTS | |
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